

Date: Monday, 2/27/2006 4:18:21 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 25980
Estimate Number : 10523
P.O. Number : N/A Part Number : D26652
This Issue : 2/27/2006 S.O. No. : N/A Drawing Number : D2665 REV. B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 24848 Material : N/A
Written By : SEE COMMENT BELOW Due Date : 3/25/2006 Qty: 12 Um: Each
Checked & Approved By : JF 06.02.28
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

B24851

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

SA 06.06.27

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

En 06.07.24 x12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.06.27 x12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 06/07/25 x12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/07/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:18:21 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 25980

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

3A0

06/07/25

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC
AL

06/07/26

12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/07/27

12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 25483

AL

06/07/27

12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/07/28

12

Job Completion



AL 06.07.28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25980
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.122	.127	.127	.125		
B	0.100	0.140		.122	.127	.127	.127		
C	0.100	0.140		.119	.123	.124	.122		
D	0.210	0.230		.226	.228	.228	.226		
E	1.245	1.255		1.250	1.250	1.250	1.260		
F	1.245	1.255		1.250	1.250	1.250	1.258		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.499	2.495	2.499	2.499		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.127	.126	.126	.126		
O	0.540	0.560		.549	.549	.548	.549		
P	0.490	0.510		.493	.498	.499	.499		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.254	.260	.261	.258		
T	0.100	0.180		.150	.150	.150	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.142	1.132	1.131	1.134		
W	1.565	1.585		1.572	1.572	1.571	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD / Ep
Date: 06/06/27 / 06/07/24

Audited by: J.F
Date: 06/07/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order:	25980
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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.126	.125	.126		
B	0.100	0.140		.123	.126	.128	.126		
C	0.100	0.140		.115	.120	.124	.123		
D	0.210	0.230		.223	.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500					
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.123	.124	.123	.124		
O	0.540	0.560		.549	.549	.547	.547		
P	0.490	0.510		.496	.498	.496	.496		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.254	.255	.257	.257		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.134	1.132	1.133		
W	1.565	1.585		1.573	1.574	1.572	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SN / EP
Date:	06.06.27 / 06/07/24

Audited by:	J.F.
Date:	06/07/25

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B	0.100	0.140		.127	.127	.127	.129		
C	0.100	0.140		.123	.122	.123	.122		
D	0.210	0.230		.227	.227	.224	.223		
E	1.245	1.255		1.258	1.250	1.256	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.678	1.678	1.679	1.679		
J	2.495	2.505		2.500	2.500	2.501	2.501		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.124	.124	.123	.123		
O	0.540	0.560		.549	.548	.548	.547		
P	0.490	0.510		.499	.497	.499	.495		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.257	.257	.256	.256		
T	0.100	0.180		.145	.143	.145	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.135	1.135	1.132		
W	1.565	1.585		1.573	1.575	1.575	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

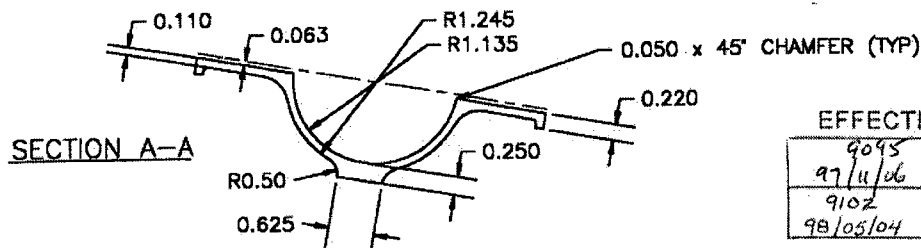
Measured by:	SA
Date:	06.06.28 / 06/07/24

Audited by:	J.F. 06
Date:	06/07/25

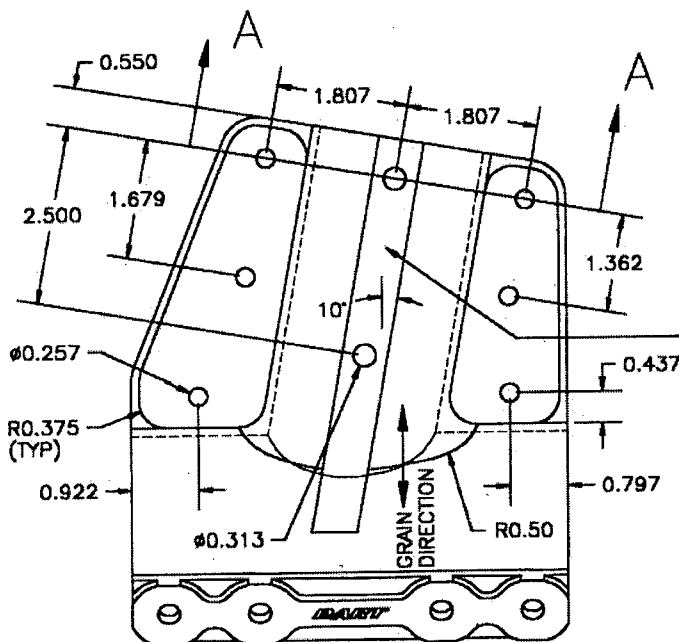
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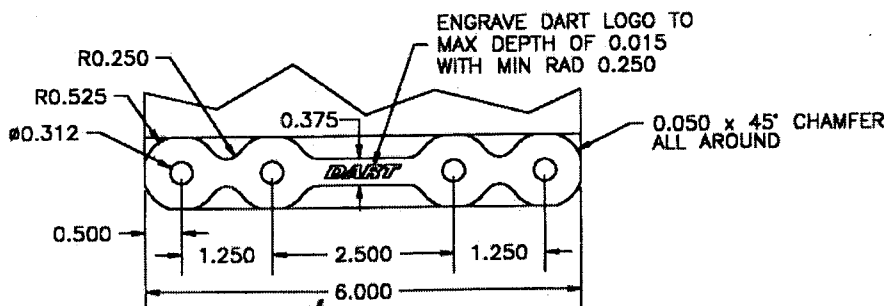
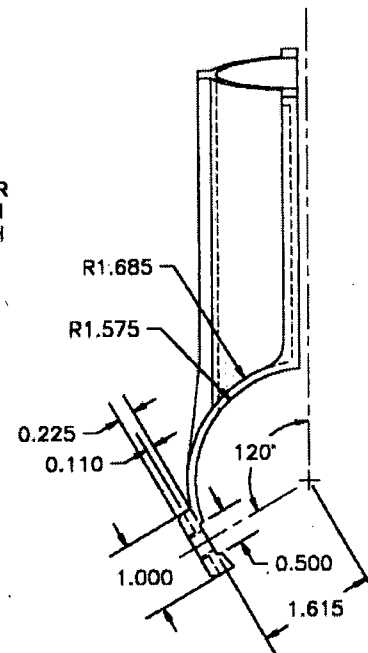
DESIGN <i>DW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DW</i>	APPROVED <i>KE</i>	DRAWING NO. D2665	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	



EFFECTIVE	DEOs
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



ENGRAVE DART LOGO TO
MAX DEPTH OF 0.015
WITH MIN RAD 0.250

MATERIAL: ~~7075-T651~~ OR 7075-T7351 (QQ-A-250/12)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2
NOTE: D2665-1 SHOWN (D2665-2 IS OPPOSITE)
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
97/07/16 DS
ECN 008

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25980

